



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2858-1
Job Sheet 211147



Part No: D2858-1

Job Qty: 10 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/7/20

Job Tracking No:

Due Date: 7/20/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		7/18/20	0.00	0.05	Bandsaw - 1		ALA 20/07/19
110	HAAS 4 Axis - B4B	10 pcs		7/18/20	1.00	2.79	HAAS - 1 - B4B		ALA 20/07/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	10 pcs		7/18/20	0.00	0.00	QC 8 - 12		AK 20/07/20
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S288926



Part: D2858-1
Job No: 211147
Serial No/Batch: S288926
Revision: C
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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TEL.: 1 613 632-5200
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www.dartaerospace.com

Date: 07/19/20



Container No: S288926



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Exp Date:

Instructions: Various STC's

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Date: 07/19/20

					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Handfinish - 1-1 Chemical-B4B	10 pcs	7/18/20	0.00 0.11	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)-B4B	10 pcs	7/20/20	0.00 0.13	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
160	QC 3	10 pcs	7/20/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	

Handwritten signature and date: 20/07/21

Handwritten date and number: 20.07.22 34-989

					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	DAS
					QC 3 - 61	32
					QC 3 - 81	J-89
					QC 3 - 82	JUL 23 2020
					QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	10	7/20/20	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180	QC 21 - SA	10	7/20/20	0.00 0.00	QC 21 - SA - 21	

M.H.

pcs

QC 21 - SA - 70

QC 21 - SA - 9

QC 21 - SA - 77

DAS

77

9-89

JUL 23 2020

Part Op **100** - (Bandsaw) Cut blanks 5.850 " Note: 1 Blank Makes 3 Parts
 Descriptions: **110** - (HAAS CNC Vertical Machine) 1-Machine per folio FA941 FOLIO REV: AA DWG REV: C 2-Deburr
 any rough edges
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 1:05 OVEN TEMPERATURE:
300 FINISH TIME: 1:35 M254469
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X1.500	6061-T6 Bar 1.250 X 1.500	1.6300 ft (.163 ea)	100-Bandsaw - 1	<u>S168970</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X1.500	2	16	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.171inches + 0.005 - 0.001	0.176 0.170	.173	
2	Hinge Bracket	0.400inches + 0.006 - 0.001	0.406 0.399	.405	
3	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	.125	
4	Hinge Bracket	0.328inches ± 0.010	0.338 0.318	.329	
5	Hinge Bracket	0.820inches ± 0.005	0.825 0.815	.820	
6	Hinge Bracket	1.476inches ± 0.010	1.486 1.466	1.476	
7	Hinge Bracket	0.342inches ± 0.010	0.352 0.332	.343	
8	Hinge Bracket	0.875inches ± 0.005	0.880 0.870	.875	
9	Hinge Bracket	1.560inches ± 0.030	1.590 1.530	1.565	
10	Hinge Bracket	0.147inches ± 0.010	0.157 0.137	.147	
11	Hinge Bracket	0.717inches ± 0.010	0.727 0.707	.715	
12	Hinge Bracket	0.697inches ± 0.010	0.707 0.687	.696	
13	Hinge Bracket	0.229inches ± 0.010	0.239 0.219	.231	
14	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	.125	
15	Hinge Bracket	0.063inches ± 0.010	0.073 0.053	.062	
16	Hinge Bracket	0.063inches ± 0.010	0.073 0.053	.062	
17	Hinge Bracket	0.126inches ± 0.010	0.136 0.116	.127	
18	Hinge Bracket	0.630inches ± 0.010	0.640 0.620	.630	
19	Hinge Bracket	0.354inches ± 0.010	0.364 0.344	.352	
20	Hinge Bracket	0.965inches ± 0.010	0.975 0.955	.967	
21	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166	.165	
22	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	.125	
23	Hinge Bracket	32.700Degrees ± 0.500	33.200 32.200	32.5	